

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75141

Monday, October 17, 2011 4:02:06 PM

75141

Page 2

Item ID: D3372-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Collective Lock Assembly
Start Date: 10/17/2011 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 10/24/2011 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					2			FF 12-08-16
Small Fab	Memo	0.00							
Small Fab	1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads								
	Qty Part NumberDescription Batch								
	A/R N/A Locktite 262 120369								
	Identify as D3372-053								
	2-Assemble D3372-051 as per Dwg								
140		0.00							
140	Large Fab					2			EL 12-8-17
Large Fab	Memo	0.00							
Large Fab	Tack weld lock shaft as per Dwg D3372								
	A/R SS Rod Batch 1114509								

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Page 3

Item ID: D3372-041 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Collective Lock Assembly
Start Date: 10/17/2011 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 10/24/2011 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC9- Inspect visual per QS1004- Fusion Welds Memo	0.00 0.00		68-8 01 SV0		12.08.17		(2)	
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 16 9-89		12/16/20		(2)	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>491</u> Memo	0.00 0.00				(2)		12/18/20	

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Work Order ID 75141

Monday, October 17, 2011 4:02:06 PM

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Item ID: D3372-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Collective Lock Assembly

Stop

NS2

Start Date: 10/17/2011 Start Qty: 3.00

3

Cust Item ID:

Required Date: 10/24/2011 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

ML5 12/08/23

MF

12-08-20

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NOTE: Date & initial all entries

Picklist Print

Monday, October 17, 2011 4:02:05 PM

Page 1

Work Order ID: 75141

Parent Item: D3372-041

Start Date: 10/17/2011

Required Date: 10/24/2011

Parent Item Name: Collective Lock Assembly

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
IPP Rev:B Added Key ID _____ 06.03.21 EC
10.05.13 verified :EC

IPP Rev:C added D3384-043 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC SS Flat Washer 5/16 FW516S1		Purchased	No			100	Each	1,558.0000	2	6	2	FF 12-08-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st376		1161							
				117332		1161							
				ST377		397							
				115072		79				4			
				115174		57							
				116643		261							
AN5-42A Bolt		Purchased	No	119449		100	Each	22.0000	1	3	2	FF 12-08-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST341		22							
				108442		22							
AN960-416 Washer	NAS1149F0463P	Purchased	No	122378		100	Each	0.0000	2	6	4	FF 12-08-20	
D2728-7 Dart Logo label		Manufactured	No	22554		100	Each	0.0000	0	0	2	FF 12-08-20	
D3372-1 Main Body		Manufactured	No			100	Each	4.0000	1	3	2	FF 12-08-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		4		03687					
				70038		4							
D3372-5 Cam Lock Shaft		Manufactured	No			100	Each	5.0000	1	3	2	FF 12-08-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST048	88931	5				1			
				59557		1							
				70035		4							

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Page 2

Work Order ID: 75141

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 10/17/2011

Required Date: 10/24/2011

Start Qty: 3.00

Required Qty: 3.00

D3372-7	Manufactured	No	100	Each	5.0000	1	3	② FF 12-08-20
Slider Body								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		2	
			ST485 79040	5				
			69633	1				
			70036	4				
D3373-1	Manufactured	No	100	Each	27.0000	1	3	② FF 12-08-20
Cam Lock								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		2	
			ST049 75666	27				
			58463	7				
			74862	20				
X D3384-043	Manufactured	No	100	Each	10.0000	1	3	② FF 12-08-20
Cyclic Sock Assembly								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		2	
			ST480 87285	6				
			74729	6				
			ST486	4				
			70037	4				
HX-81	Purchased	No	100	Each	20.0000	1	3	② FF 12-08-20
1/4"-20 SHCS 3/8" long								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		2	
			ST390 120773	20				
			114383	20				

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Shop Packet Print

Page 2

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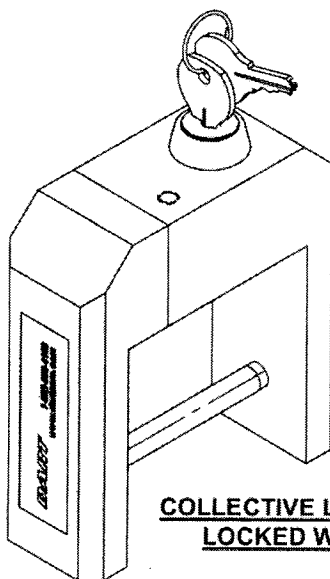
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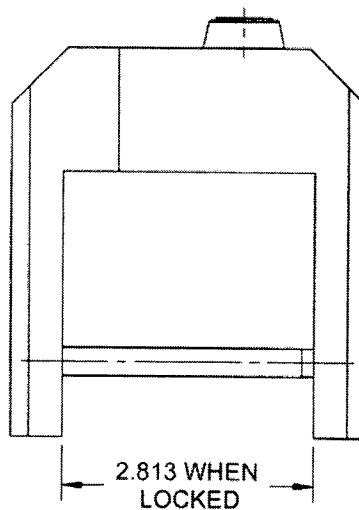
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE	05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



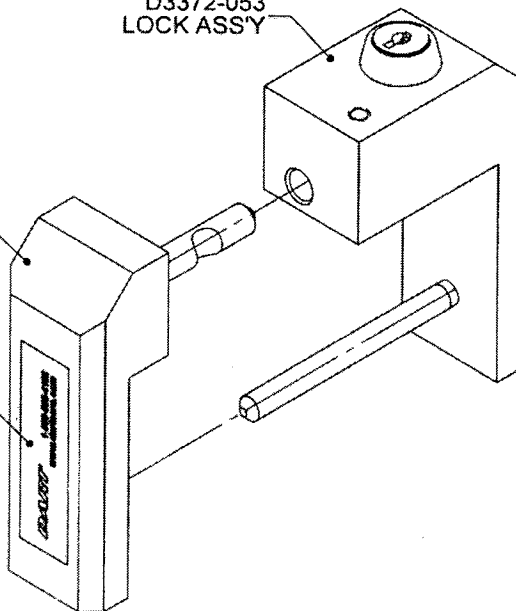
**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



D3372-053
LOCK ASS'Y

D3372-055
SLIDER ASS'Y

D2728-7
LABEL (1)



RELEASED
05/04/28

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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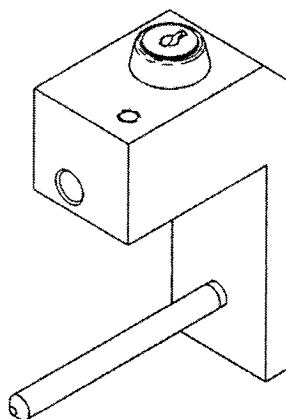
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3372	REV. B SHEET 2 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2

RELEASED
05/04/23



D3372-1
MAIN BODY (1)

D3372-3
GUIDE (1)

D3373-1 CAM LOCK ASS'Y (1)

5/16 WC SS.
FLAT WASHER (2)
(AS PER D3371)

D3369-5 SPACER (1)
(AS PER D3373-1)

TACK WELD
D3372-5
TO D3369-5

D3372-5 CAM
LOCK SHAFT (1)

SECTION A-A

D3372-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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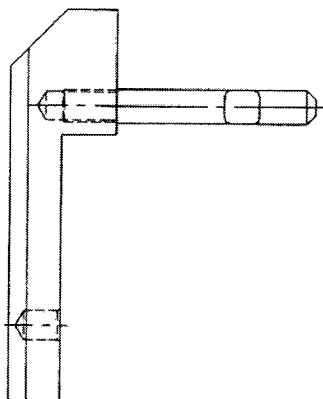
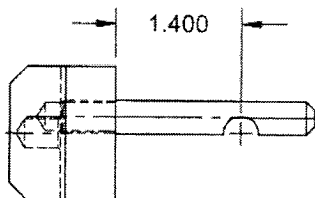
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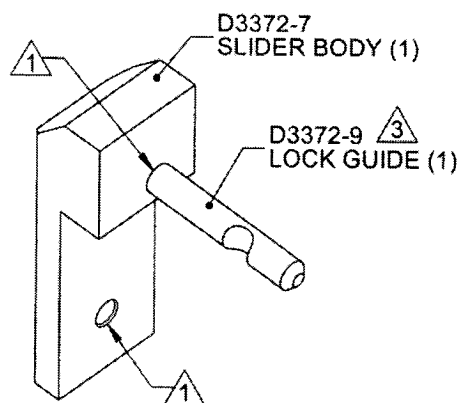


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 3 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



#75741

RELEASED
[Signature]
05/04/23



D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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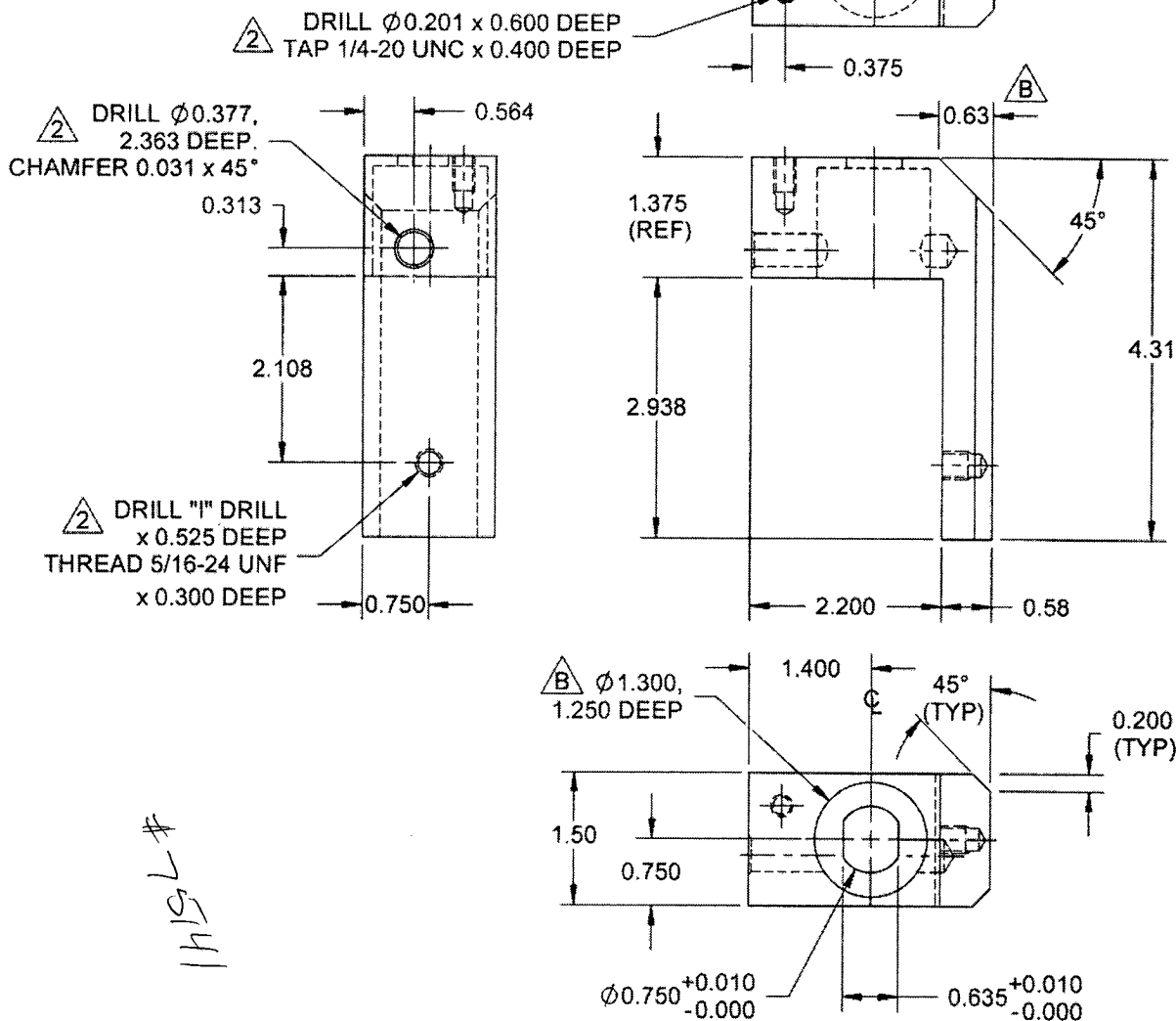
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NOTE: Date & initial all entries



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED B	DRAWING NO. D3372	REV. B SHEET 4 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2

RELEASED
05/04/23



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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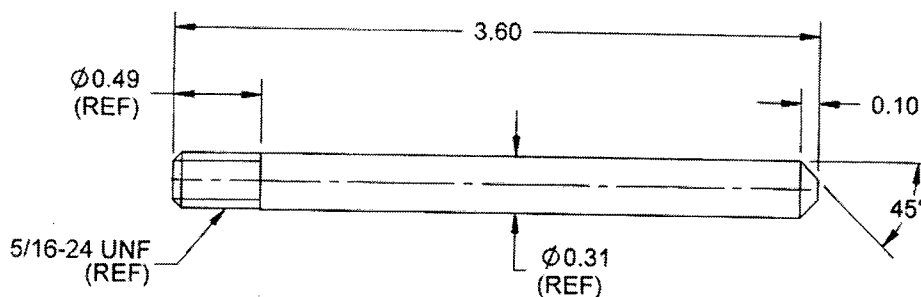
NOTE: Date & initial all entries



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CHECKED <i>TF</i>	APPROVED <i>AB</i>	DRAWING NO. D3372	REV. B SHEET 5 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

RELEASED
AB
05/04/23



#1156

D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

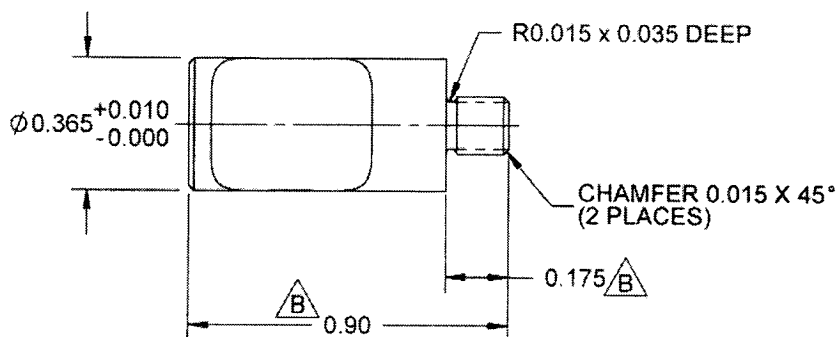
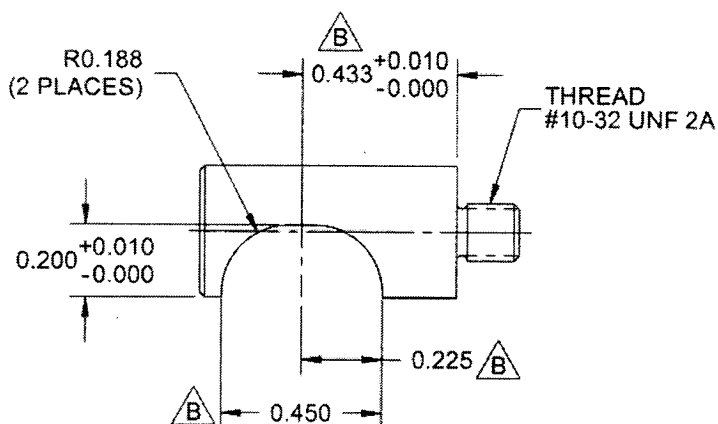
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 6 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28



#75/41

D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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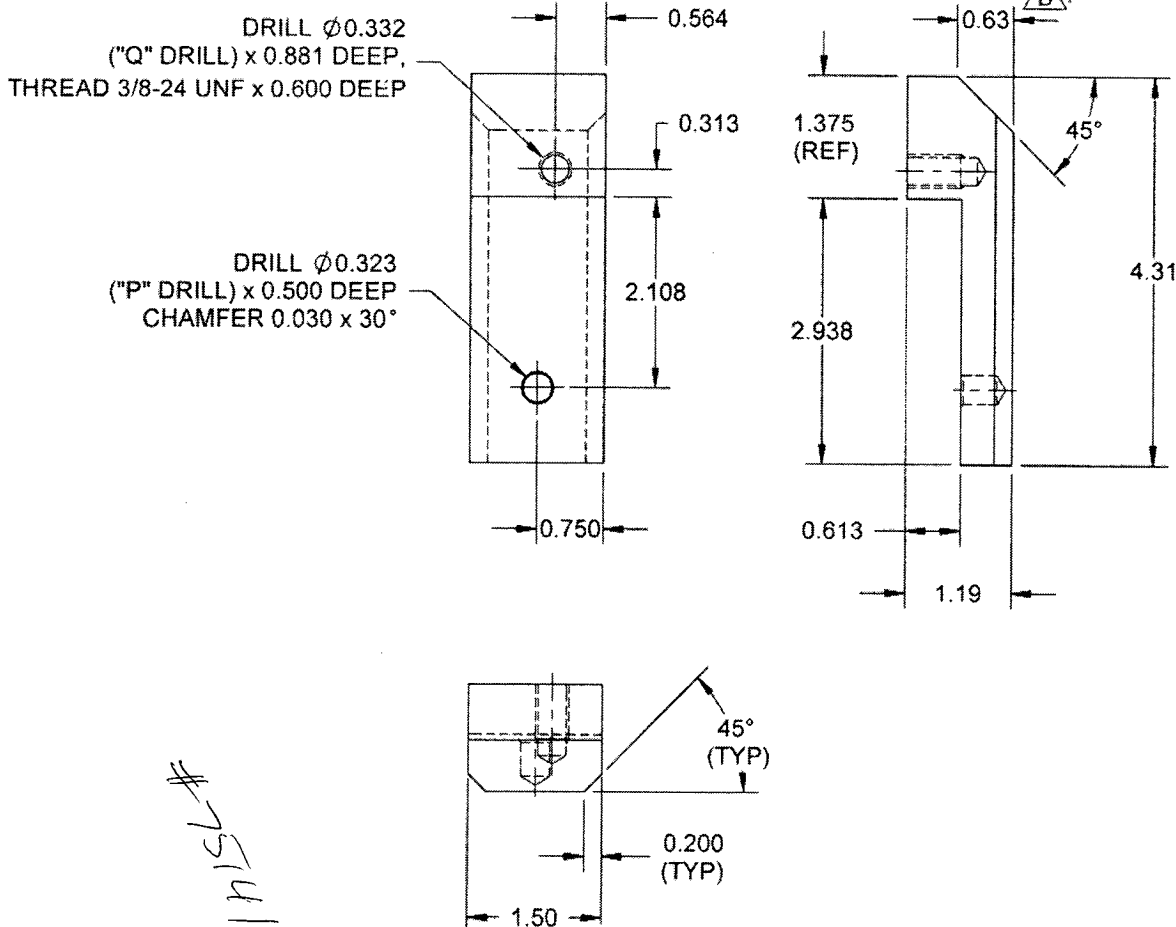
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 7 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

RELEASED
[Signature]
05/04/28
B



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

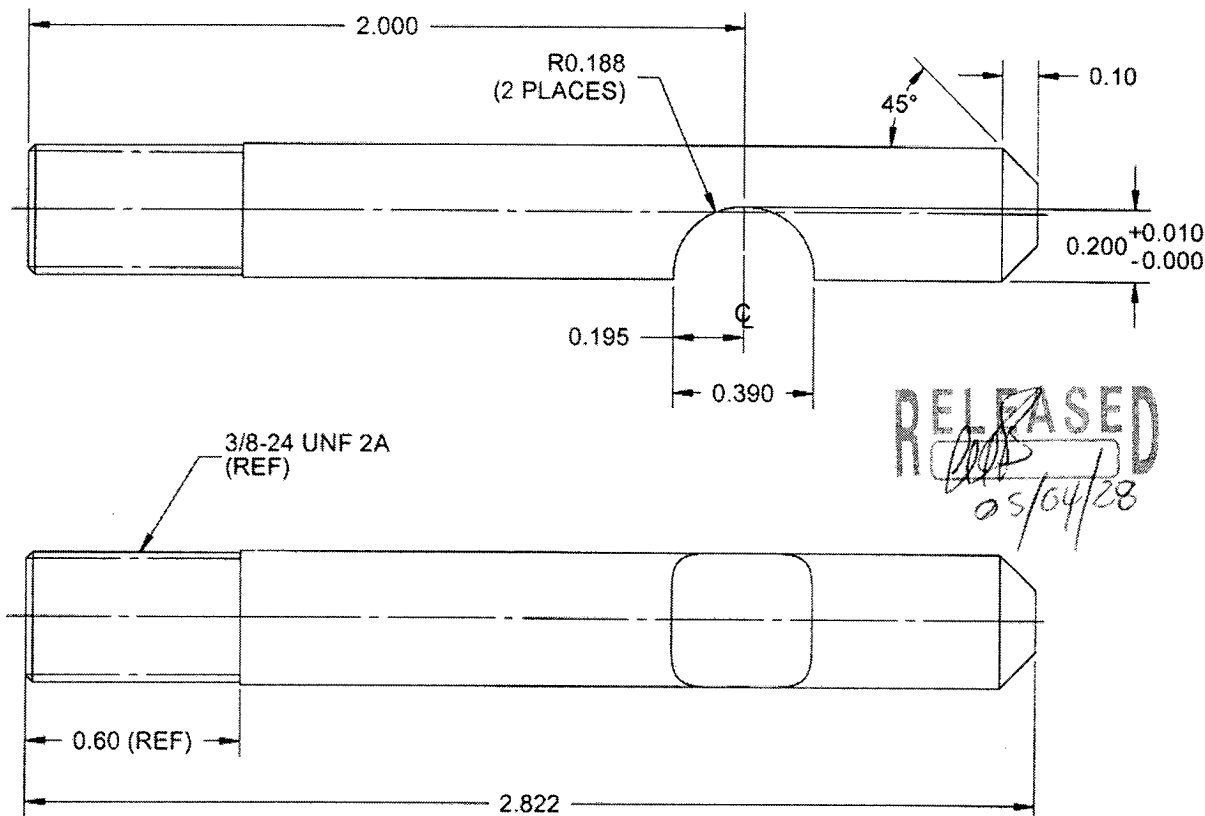
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries